

Work Order ID 114039

March-03-14 12:40:39 PM

114039

Page 1

Item ID: D3649-041

Accept

Revision ID:

Item Name: Tunnel Bottom Panel Assy

Setup Start *NS1*

Stop *NS2*

Start Date: 3/03/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/17/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M-3

Date: 14-03-03

Tooling: _____

Date: _____

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/ Work-Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3649	Rev B								

100 *100* FLOW WATER JET

Waterjet

Memo 0.00

6 2 14-3-10

FLOW CNC Waterjet

1-Cut as per Dwg D3649 Dwg Rev: B Prog Rev: B 2.
Deburr if necessary

110 *110* QC2- Inspect parts off machine FAI/FAIB 0.00

QC

Memo 0.00

6 2 14-3-10

Quality-Control

120 *120* QC8- Inspect parts - second check 0.00

QC

Memo 0.00

DAS
27
9.95
14/3/11

6 _____

Quality-Control

Work Order ID 114039

114039

Page 3

March-03-14 12:40:39 PM

Item ID: D3649-041

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Tunnel Bottom Panel Assy

Stop

NS2

Start Date: 3/03/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/17/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00	DAS 27 9-89	1					
170 *170* Packaging Packaging	Identify as per dwg & Stock Location Memo	0.00	8371			1X		14-7-22	DAS 26 9-89
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00				MJ	14-07-22		

W/M 07.22

Picklist Print

Page 1

March-03-14 12:40:43 PM

Work Order ID: 114039

114039

Parent Item: D3649-041

D3649-041

Parent Item Name: Tunnel Bottom Panel Assy

Start Date: 3/03/14

Required Date: 3/17/14

Comments: IPP Rev:A New Issue 07-09-26 EC verified by: DD
 IPP Rev:B ECN 1113P 08-01-22 DD verified by: EC
 IPP Rev:C Ecn1162 08-04-02 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S26GA		Purchased		No		150	sf	149.0000	6.069	7		**	

M304S26GA

304/316 0.018 SHEET

Location Loc Qty Loc Code

MAT020 149

122753 26

123135 123

MS20427M3-3

Purchased No

110 Each 882.0000 88

**

14-7-21

DAS
36
9-89

MS20427M3-3

Rivet

Location Loc Qty Loc Code

GA 491

121114- 491

ST335 391

124231- 391

MS21060-3K

Purchased No

150 Each 77.0000 22

**

42

486

DAS
36
9-89

MS21060-3K

Nut Plate

Location Loc Qty Loc Code

ST316 77

m126826 77

77

M128829 50x

M129864 5x

Picklist Print

Page 2

March-03-14 12:40:43 PM

Work Order ID: 114039

114039
D3649-041

Parent Item: D3649-041

Parent Item Name: Tunnel Bottom Panel Assy

Start Date: 3/03/14

Required Date: 3/17/14

MS21062-3K

Purchased

No

150

Each

142.0000

22

22

**

Start Qty: 1.00

Required Qty: 1.00

MS21062-3K

Nut Plate

14/07/18

9-89
36
DAS

Location	Loc Qty	Loc Code
GA	42	
124316	42	39
ST317	100	
124329	100	93

DART AEROSPACE LTD		Work Order:	114039
Description: Tunnel Bottom Panel		Part Number:	D3649-1
Inspection Dwg: D3649	Rev: B		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.102	✓		U - SKM05	
Ø0.196	+0.005/-0.001	0.198	✓			
Ø0.250	+0.005/-0.001	0.255	✓			
0.400	+/-0.010	0.401	✓			
0.385	+/-0.010	0.386	✓			
0.250	+/-0.010	0.251	✓			
44.57	+/-0.030	44.57	✓		T SKM07	
11.70	+/-0.030	11.7	✓		"	
3.370	+/-0.030	3.370	✓		✓	
13.76	+/-0.030	13.75	✓			
4.300	+/-0.010	4.30	✓			
10.11	+/-0.030	10.115	✓			
12.90	+/-0.030	12.918	✓			
16.61	+/-0.030	16.615	✓			
15.80	+/-0.030	15.81	✓			
3.950	+/-0.010	3.958	✓			
0.42	+/-0.030	0.426	✓			
0.41	+/-0.030	0.415	✓			
0.85	+/-0.030	0.851	✓			
19.64	+/-0.030	19.642	✓			
0.54	+/-0.030	0.546	✓			
1.400	+/-0.010	1.407	✓			
2.63	+/-0.030	2.64	✓			
2.93	+/-0.030	2.93	✓			
1.49	+/-0.030	1.49	✓			
5.98	+/-0.030	6.98	✓			
0.54	+/-0.030	0.54	✓			
2.20	+/-0.030	2.20	✓			
2.75	+/-0.030	2.75	✓			
2.48	+/-0.030	2.48	✓			

DART AEROSPACE LTD		Work Order:	114039
Description: Tunnel Bottom Panel		Part Number:	D3649-1
Inspection Dwg: D3649	Rev: B		Page 2 of 2

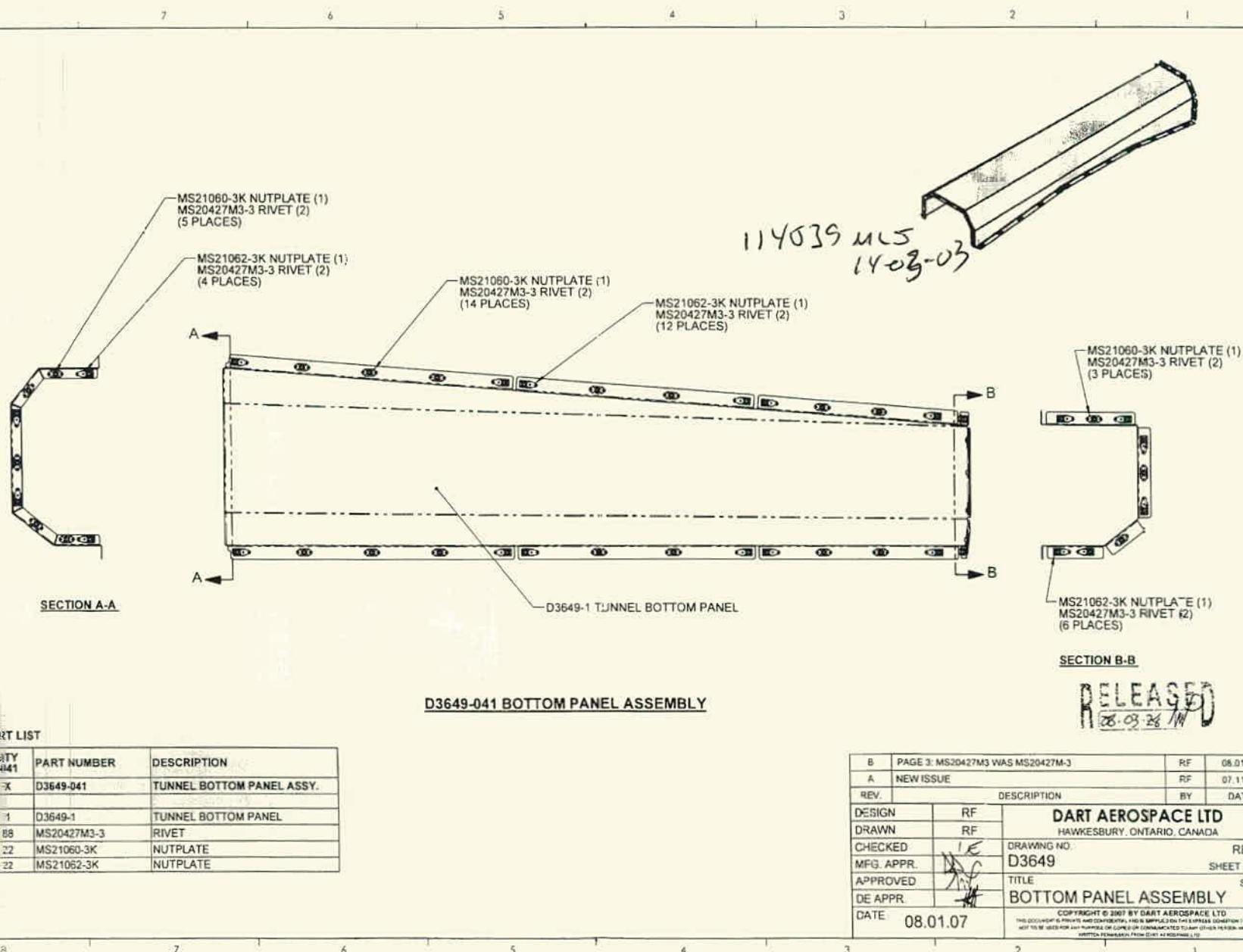
FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.16	+/-0.030	1.16	/			
3.38	+/-0.030	3.38	/			
2.00	+/-0.030	2.00	/			
0.90	+/-0.030	0.90	/			
16.64	+/-0.030	16.64	/			
0.48	+/-0.030	0.48	/			
13.80	+/-0.030	13.8	/			
0.46	+/-0.030	0.46	/			
11.76	+/-0.030	11.76	/			
1.23	+/-0.030	1.23	/			
0.88	+/-0.030	0.89	/			
18.46	+/-0.030	18.47	/			
5.23	+/-0.030	5.23	/			
1.932	+/-0.010	1.936	/			
1.943	+/-0.010	1.944	/			
5.02	+/-0.030	5.03	/			
1.820	+/-0.010	1.825	/			
0.70	+/-0.030	0.73	/			
2.100	+/-0.010	2.110	/			
2.33	+/-0.030	2.34	/			
0.94	+/-0.030	0.96	/			
3.30	+/-0.030	3.30	/			
1.900	+/-0.010	1.9	/			
0.61	+/-0.030	0.61	/			

Measured by:	DL	Audited by:	DAS 27	Prototype Approval:	N/A
Date:	14-3-10	Date:	14/3/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	BB



8

7

6

5

4

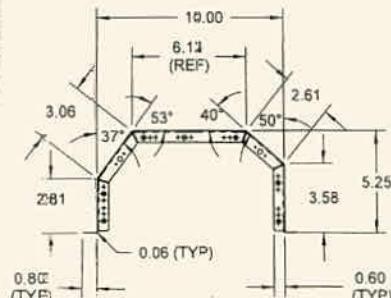
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2

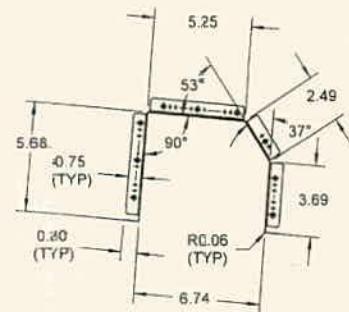
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D

D

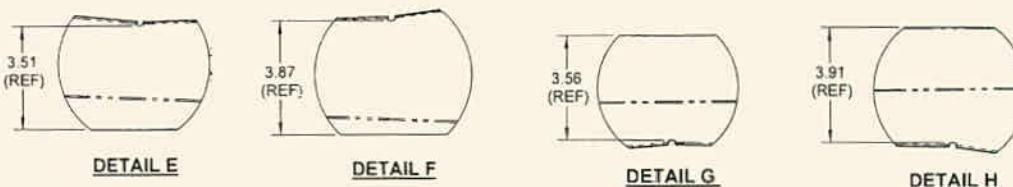


SECTION C-C



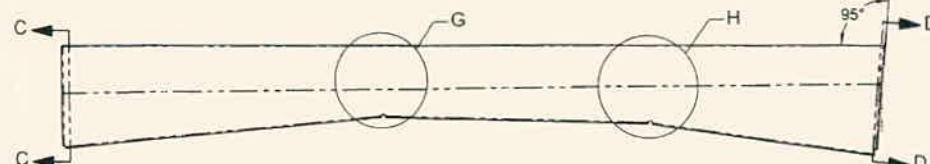
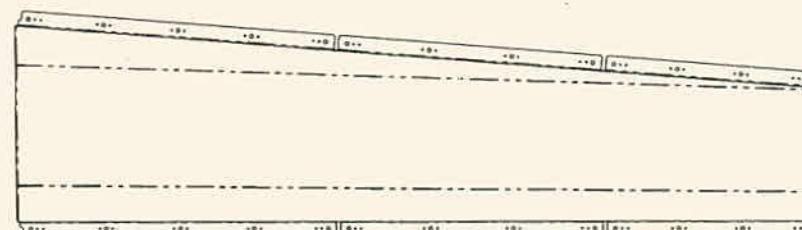
SECTION D-D

D3649-1 TUNNEL BOTTOM PANEL
(MAKE FROM D3649-1F)



E

F

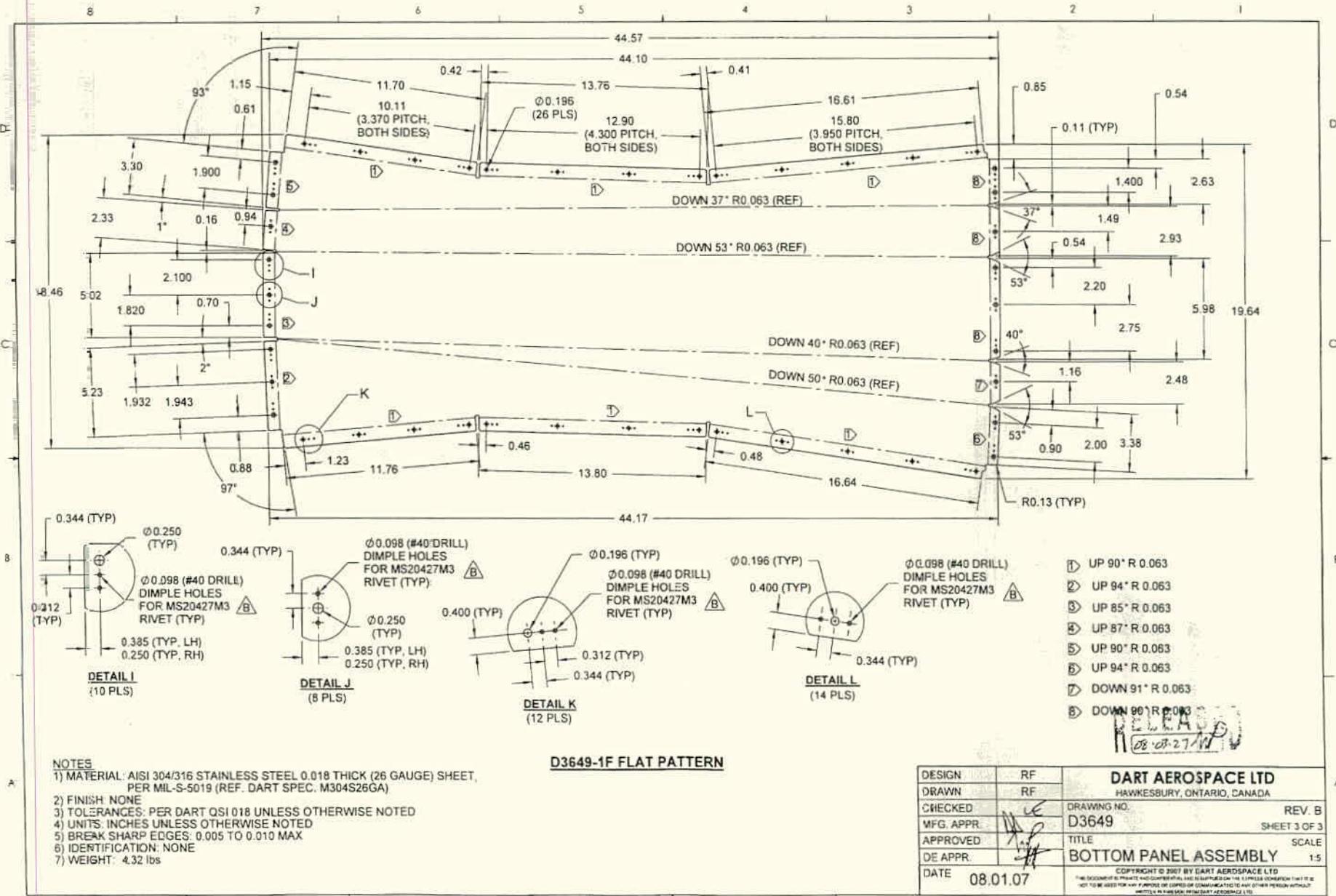


RELEASED
08-03-27-117

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>LE</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>LE</i>	D3649	SHEET 2 OF 3
APPROVED	<i>LE</i>	TITLE	SCALE
DE APPR.	<i>LE</i>	BOTTOM PANEL ASSEMBLY	
DATE	08.01.07	16	

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D3649-1F FLAT PATTERN

NOTES
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 4.32 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>LC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>W</i>	D3649	SHEET 3 OF 3
APPROVED	<i>AP</i>	TITLE	SCALE
DE APPR.	<i>HT</i>	BOTTOM PANEL ASSEMBLY	
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